

Split

rk Order ID 85791-2

15-12 10:47:53 AM

85791

ID: D4150-041
ion ID:
Name: Attachment Arm Assembly
Date: 15/06/2012 Start Qty: 12.00
ired Date: 22/06/2012 Req'd Qty: 12.00
rence:

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

ovals: Process Plan:
QC:

Date: Tooling:
Date: SPC (Y/N):

Date:
Date:

Run Start *NR1*
Stop *NR2*

ence ID/
k Center ID
aw Nbr
150

Operation
Description
Revision Nbr
B

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Reject
Number Insp.
Stamp

00*
l Fab
Fab

Memo
1- Assemble as per dwg

0.00
0.00

6x

12/07/4

10*
ity Control

QC 5- Inspect part completeness to step on W/O

Memo

0.00
0.00

6

12/07/4

20*
caging
aging

Identify as per dwg & Stock Location: 102

Memo

0.00
0.00

12/7/11 6

Work Order ID 85791

June-15-12 10:47:53 AM

85791

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Item ID: D4150-041

Accept

N900040100

Revision ID:

Setup Start *NS1*

Item Name: Attachment Arm Assembly

Stop *NS2*

Start Date: 15/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 12/07/12

MLF
12-07-12

Picklist Print

June-15-12 10:47:57 AM

Work Order ID: 85791

85791

Parent Item: D4150-041

D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 15/06/2012

Required Date: 22/06/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD ver:EEC
IPP Rev:B 10.07.22 as per revB DD ver:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A *AN3C13A* Bolt		Purchased	No			100	each	28.0000	2	24			

**

12/07/09

Location	Loc Qty	Loc Code
ST351	28	
117366	1	
120630	2	
121691	25	

D4150-1 *D4150-1* Arm		Manufactured	No			100	Each	7.0000	1	12			
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**

13
12/07/09

Location	Loc Qty	Loc Code
ST102	7	
82912	7	

D4150-3 *D4150-3* Arm Plate		Manufactured	No			100	Each	12.0000	2	24			
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**

B85796
12
12/07/09

Location	Loc Qty	Loc Code
ST102	12	
84988	12	

B85853
24X



Picklist Print

June-15-12 10:47:57 AM

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Work Order ID: 85791

85791

Parent Item: D4150-041

D4150-041

Parent Item Name: Attachment Army Assembly

Start Date: 15/06/2012

Required Date: 22/06/2012

Start Qty: 12.00

Required Qty: 12.00

MS21043-3

Purchased

No

100

Each

1,374.000

2

24

MS21043-3

**

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1302

118077

2

118614

81

118686

30

119758

20

121255

243

121708

956

24

NAS1149C0332R

Purchased

No

100

Each

9,880.000

4

48

NAS1149C0332R

**

Washer

Location

Loc Qty

Loc Code

297

9852

122063

9852

ST297

26

121255

26

ST298

2

121509

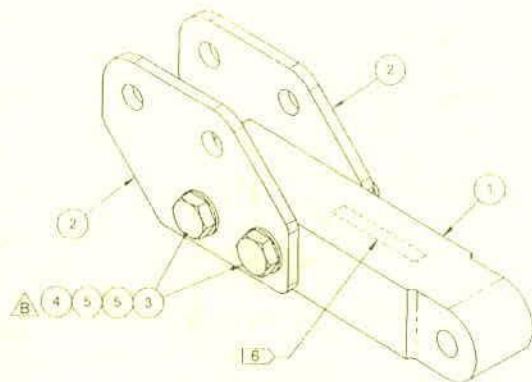
2

48

June-15-12 10:47:57 AM

Shop Packet Print

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D4150-041 ATTACHMENT ARM ASSY

ITEM	QTY	P/N	DESCRIPTION
	1	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	4	MS21043-3	NUT
5	9	NAS1149C0J32R	WASHER

RELEASED
2010-07-16

- NOTES**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.82 lbs

REV	DESCRIPTION	BY	DATE
B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C 13A, MS21043-3 AND QTY(4) NAS1149C0J32R WASHER (2N D3-1), 20 191 2 PL REPLACES 20 129 3 PL (2N CH-2, C7-2, B4-3 & R5-3) REASON: SEE TR-D350-007-2 REV B	MB	10 07 08
A	NEW ISSUE	MB	10 06 10

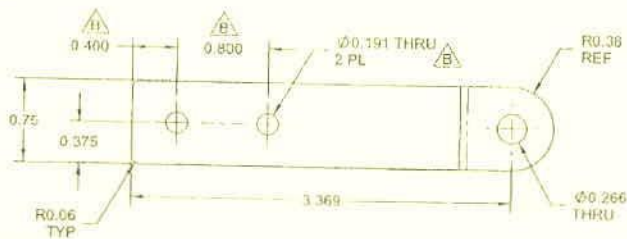
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DRAWING NO. D4150	REV. B
CHECKED	SHEET 1 OF 3	
MFG. APPR.	TITLE	SCALE
APPROVED	ATTACHMENT ARM ASSY	
DE APPR.	NTS	
DATE	10.07.08	

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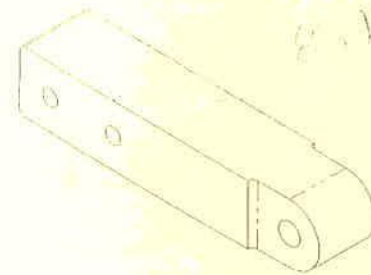
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PHYSICS DEPARTMENT



D4150-1 ARM

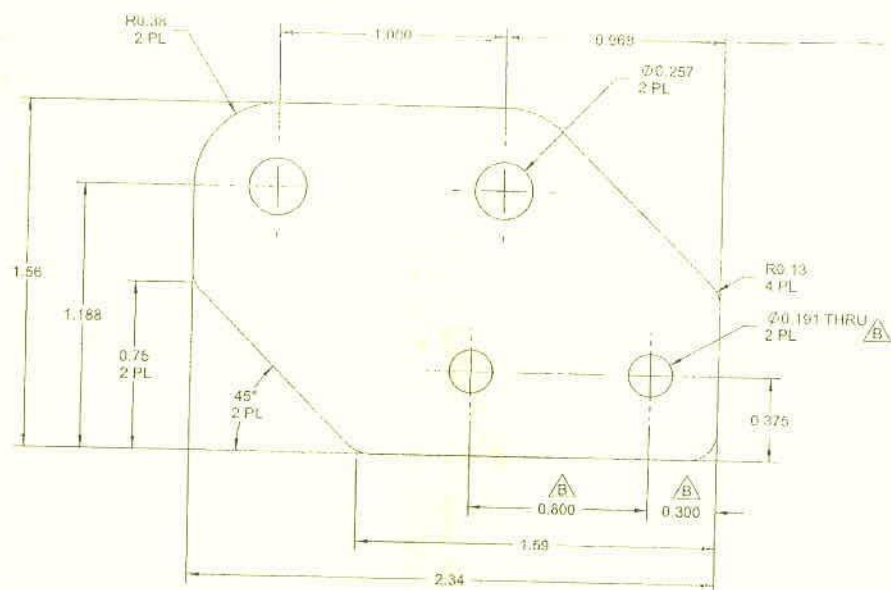


RELEASED
2010-07-16

NOTES

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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D4150-3 ARM PLATE

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 304/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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